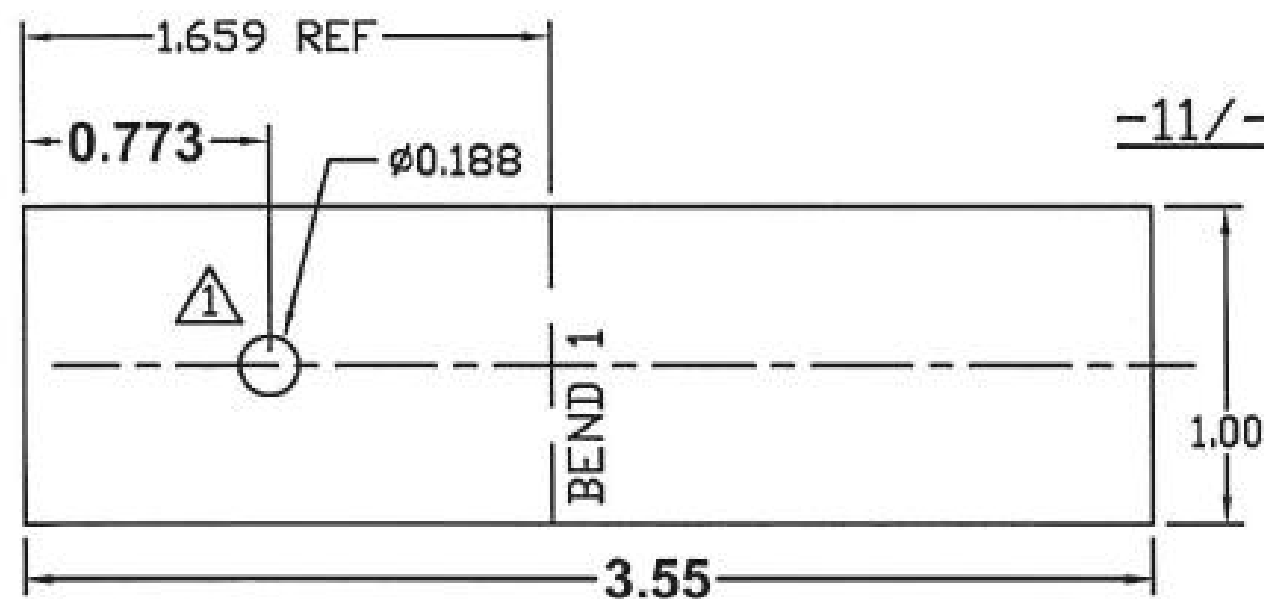
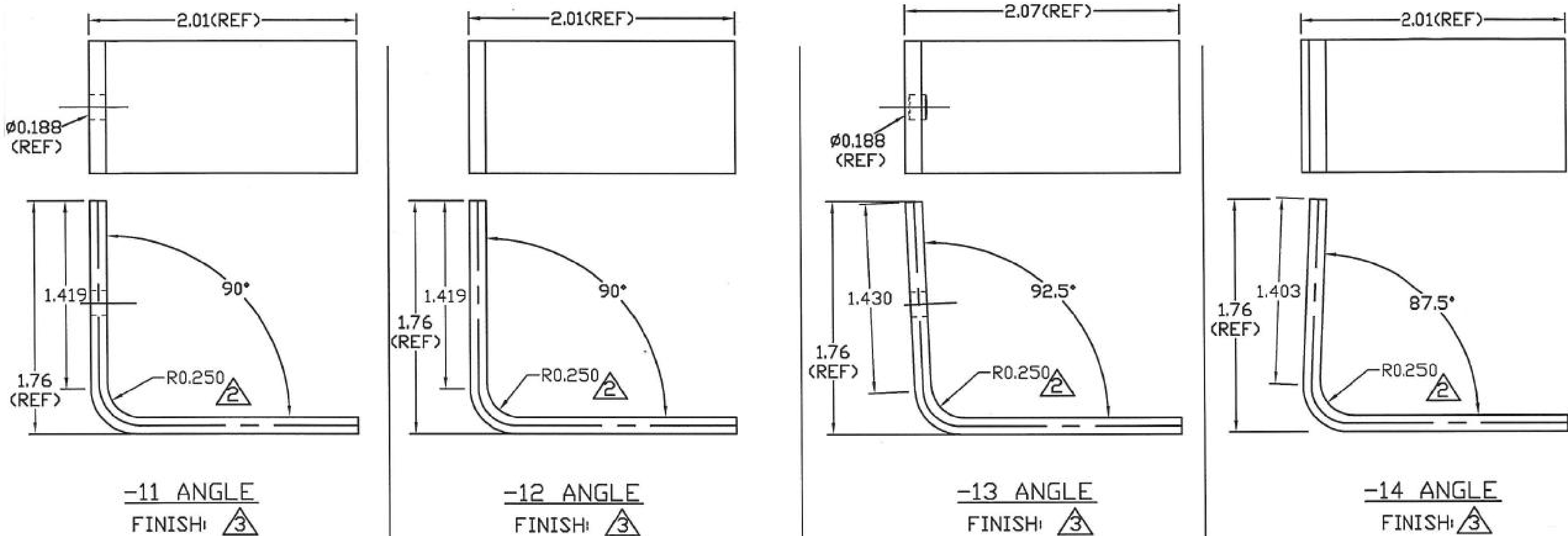


- NOTES:
- 1 THIS HOLE IN -11/-13 FLAT PATTERN ONLY
- 2 INSPECT RADIUS WITH BRIGHT LIGHT AND 10X GLASS AFTER BENDING. PERFORM DYE PENETRANT INSPECTION ON ANY SUSPECT AREAS PER AMS2644, TYPE 2, METHOD A, LEVEL 1 MINIMUM, REF. ASTM E1417 AND MFR'S DATA.
- 3 FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE 11, CLASS 2
ALT FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N

REVISION HISTORY						
DATE	REV	ECO	DESCRIPTION	AUTHOR	CHECKED	APPROVED
9/2/10	A	-	-1,-2,-3,-4 (0.090 THICK) REPLACED BY -11,-12,-13,-14	REB	LS	REB
10/19/10	B	-	ADDED VERTICAL FLANGE DIMS, PENETRANT INSPECTION	REB	LS	REB
7/9/18	A	1	ADDED BEND CHART AND BEND 1 LINE	EW	LS	ZA
10/17/18	A	2	NOTE 2: ADDED INITIAL MAGNIFYING INSPECTION, DYE PENETRANT INSPECTION NOW ONLY ON SUSPECT AREAS	ZA	LS	ZA
9/21/20	B	-	ADDED -21, -22, -23, -24, -25	CMK	LS	CMK




BEND CHART	
BEND 1	
PUNCH	#15
DIE	#20
ANGLE	84.5
DIMENSION	1.642

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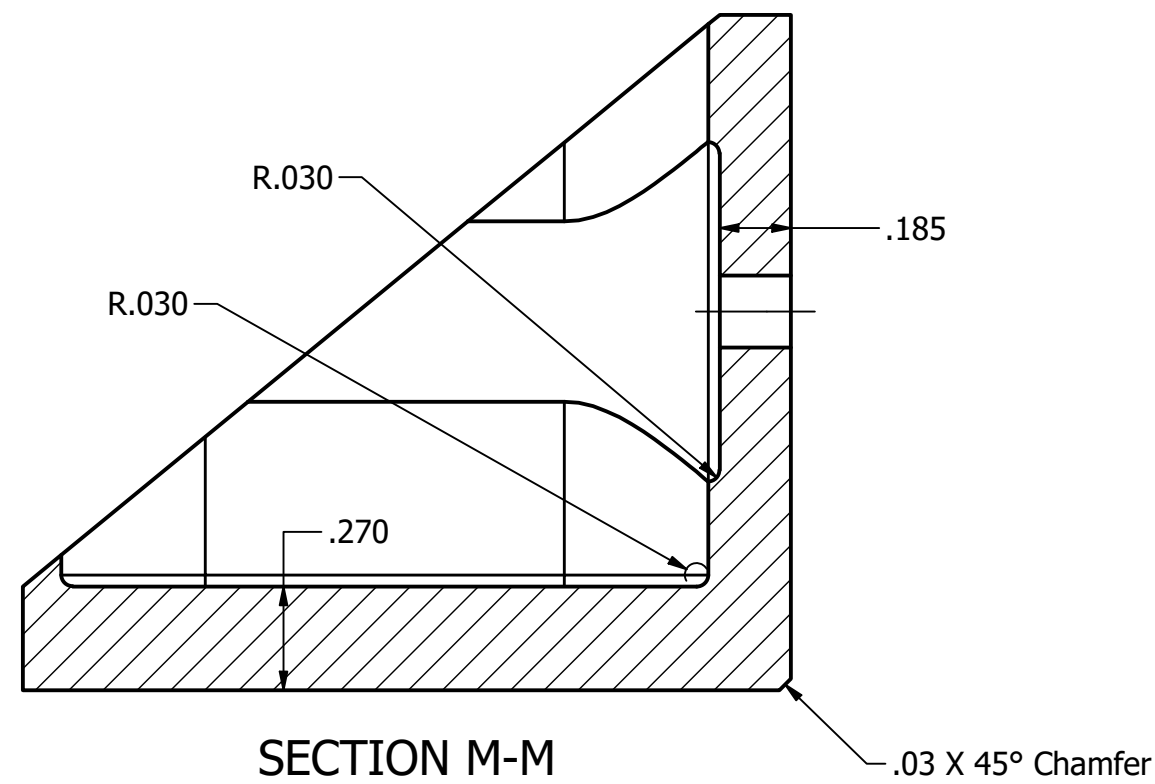
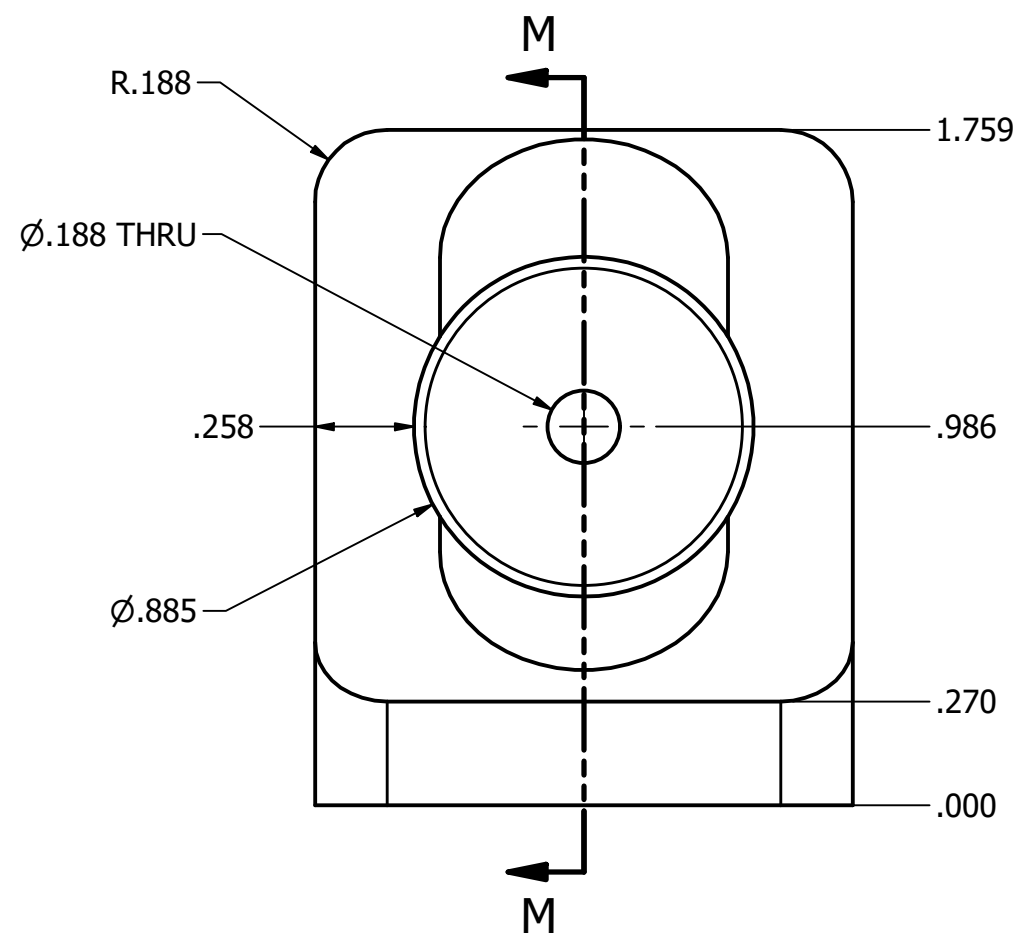
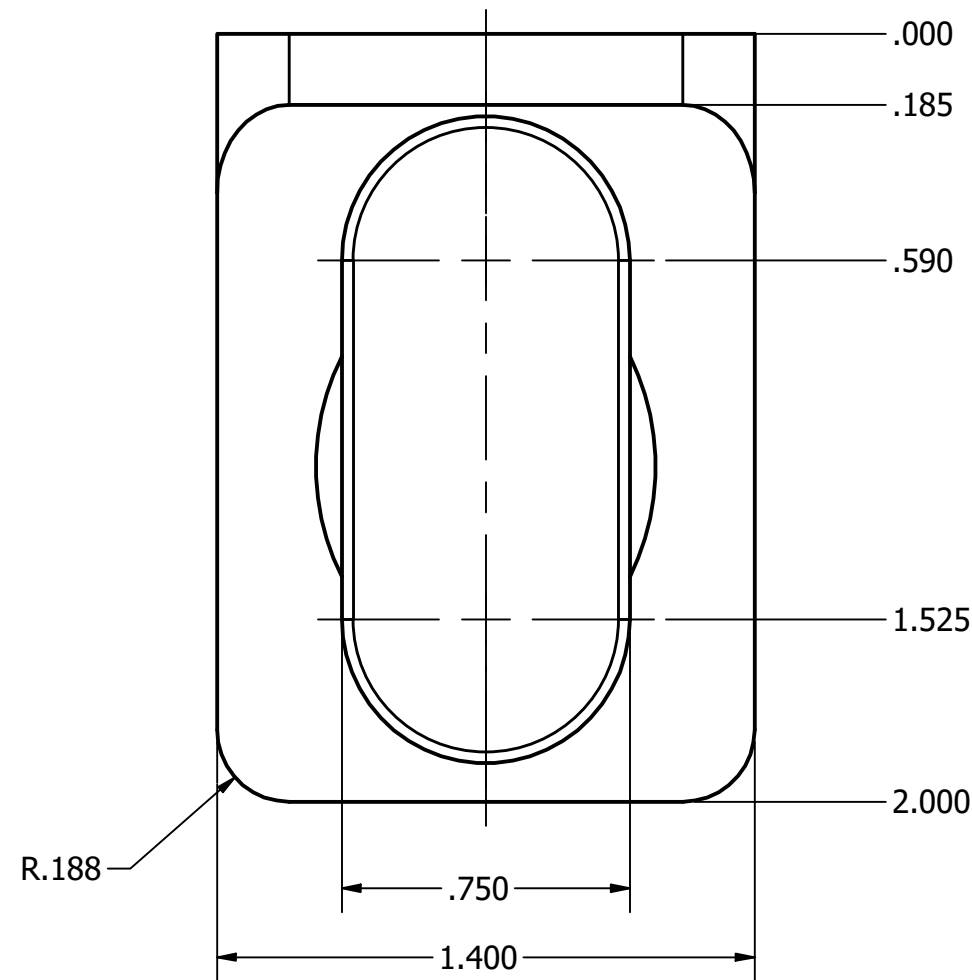
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DRAWING INTERPRETED
PER ASME Y14.100-2004
DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: \sqrt{R}
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015
X ±1
XX ±0.1
XXX ±0.005
ANGLES ±1°
THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

APPROVALS		DATE
DRAWN	BNS	9/24/08
CHECKED	LS	9/24/08
APPROVED	REB	9/24/08
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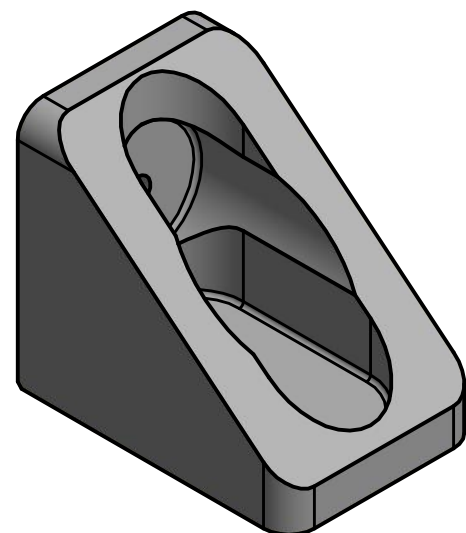
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-21 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2



SECTION M-M
SCALE 2 : 1



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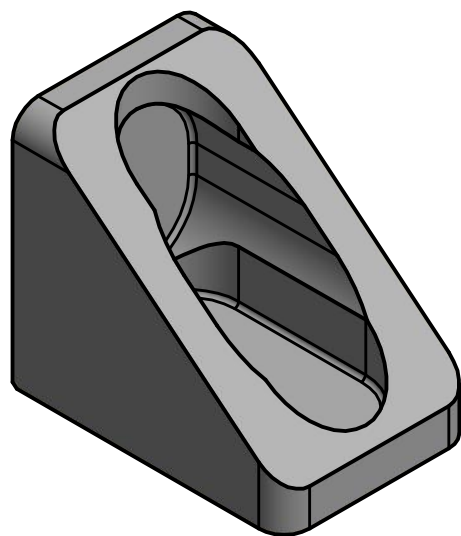
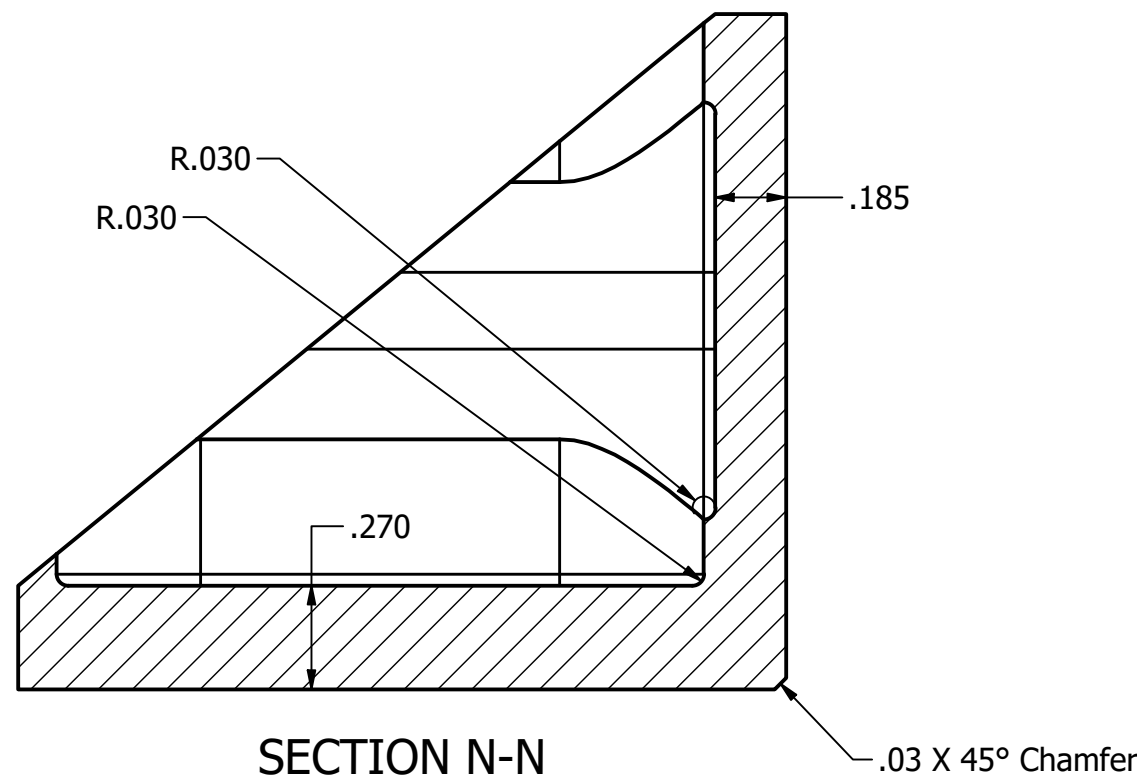
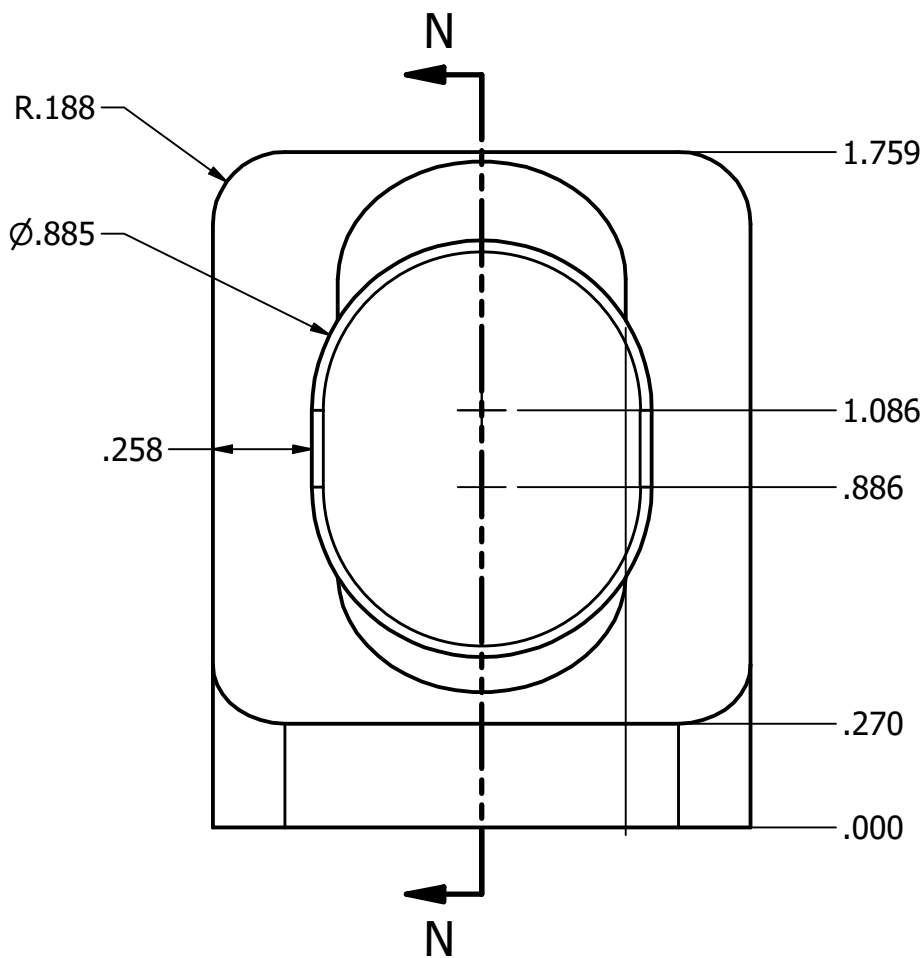
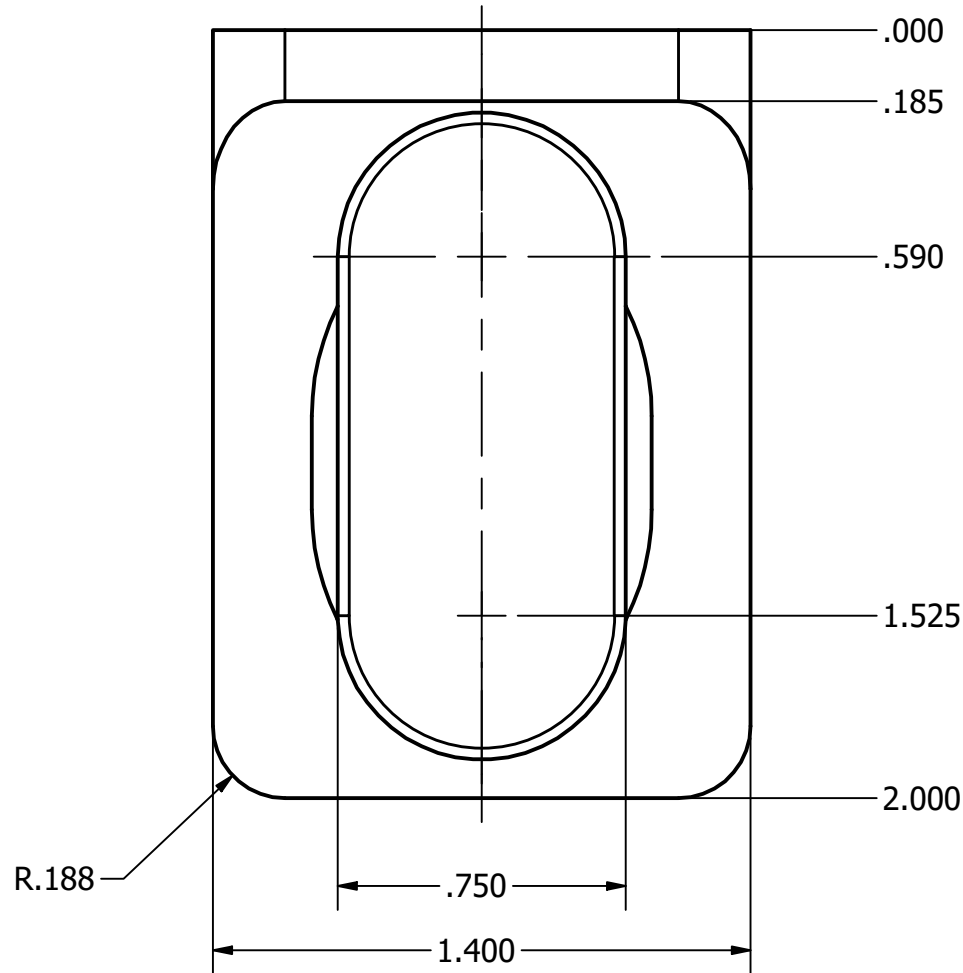
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PER ASME Y14.100-2004
DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: R_a
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015
.X ±.1
.XX ±.01
.XXX ±.005
ANGLES ±1°
THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

APPROVALS		DATE
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ANGLE					
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-22 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2



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DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: R_a
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015
.X \pm .1
.XX \pm .01
.XXX \pm .005
ANGLES \pm 1°

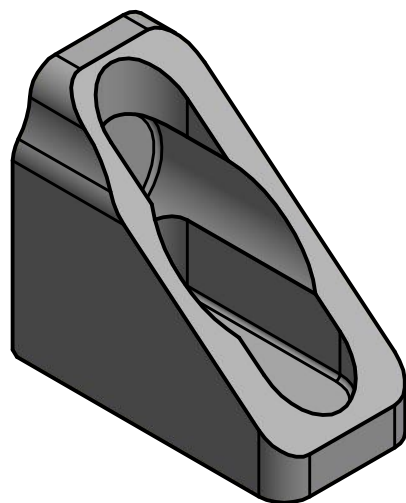
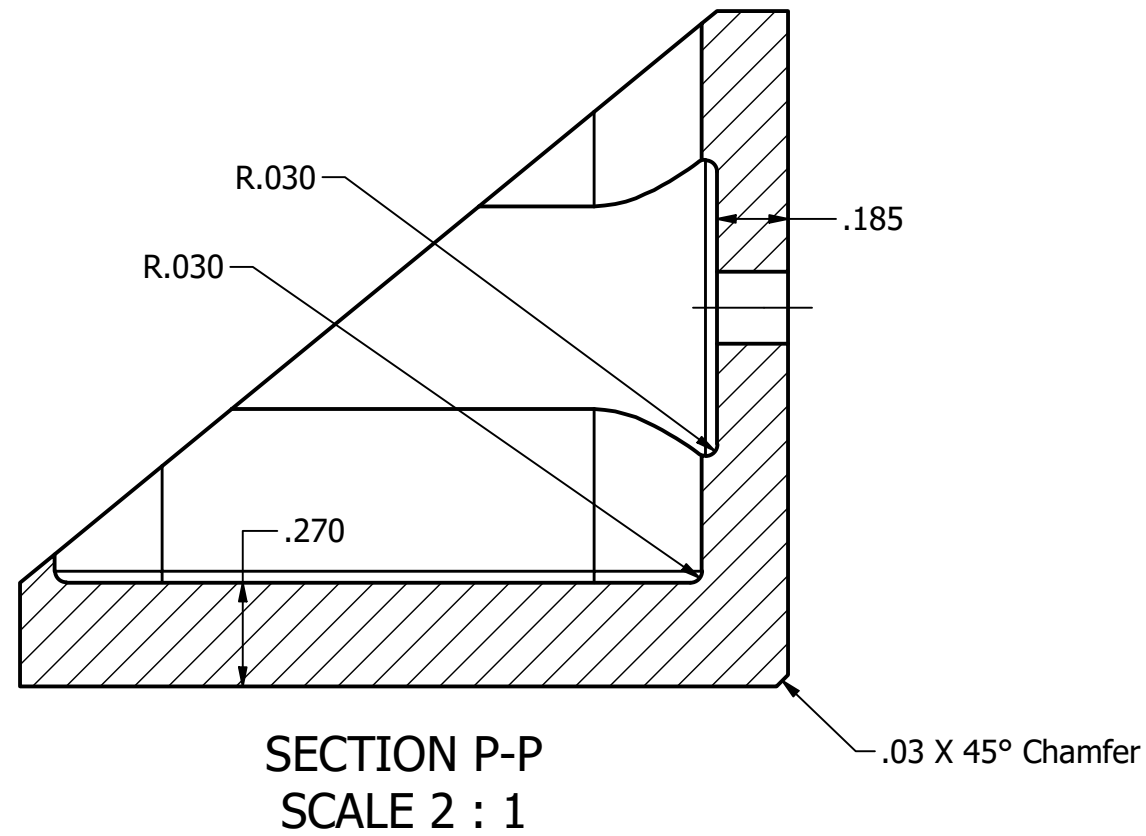
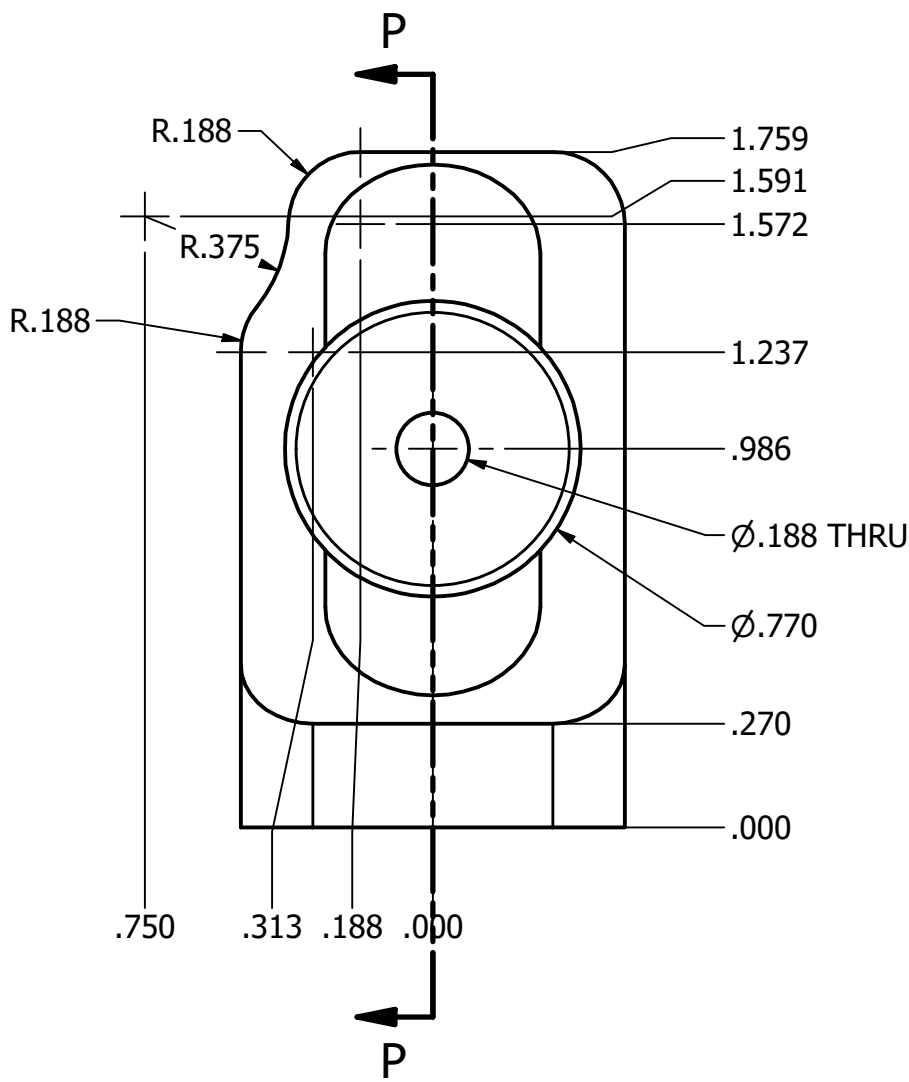
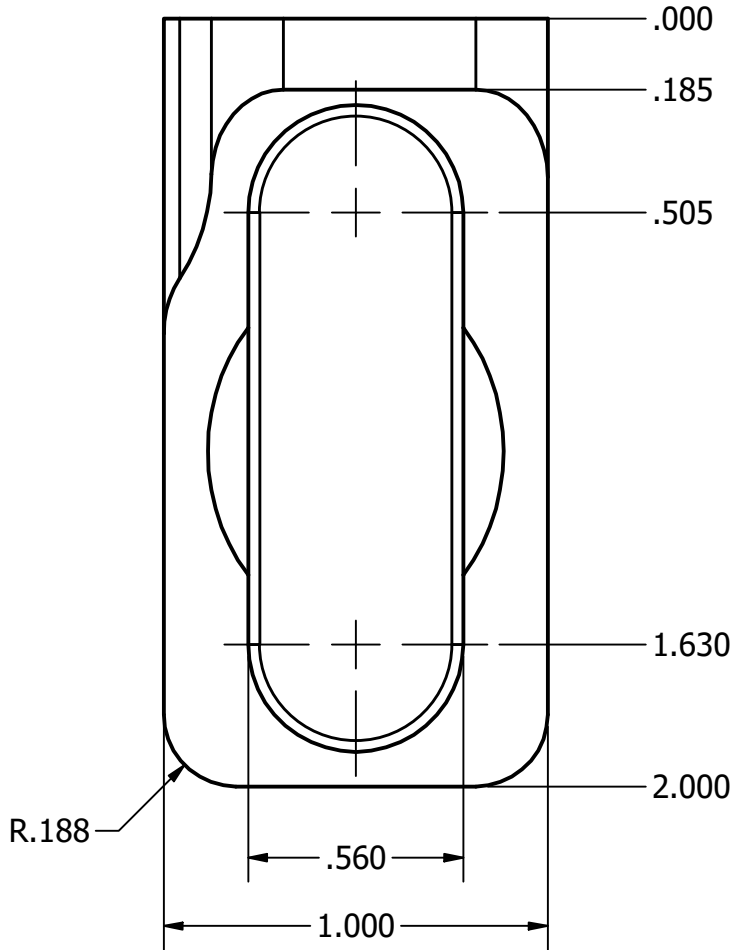
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EXTERNAL: CLASS 2A

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-23 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2



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DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: \sqrt{R}
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015

.X ±.1
.XX ±.01
.XXX ±.005
ANGLES ±1°
THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

APPROVALS		DATE
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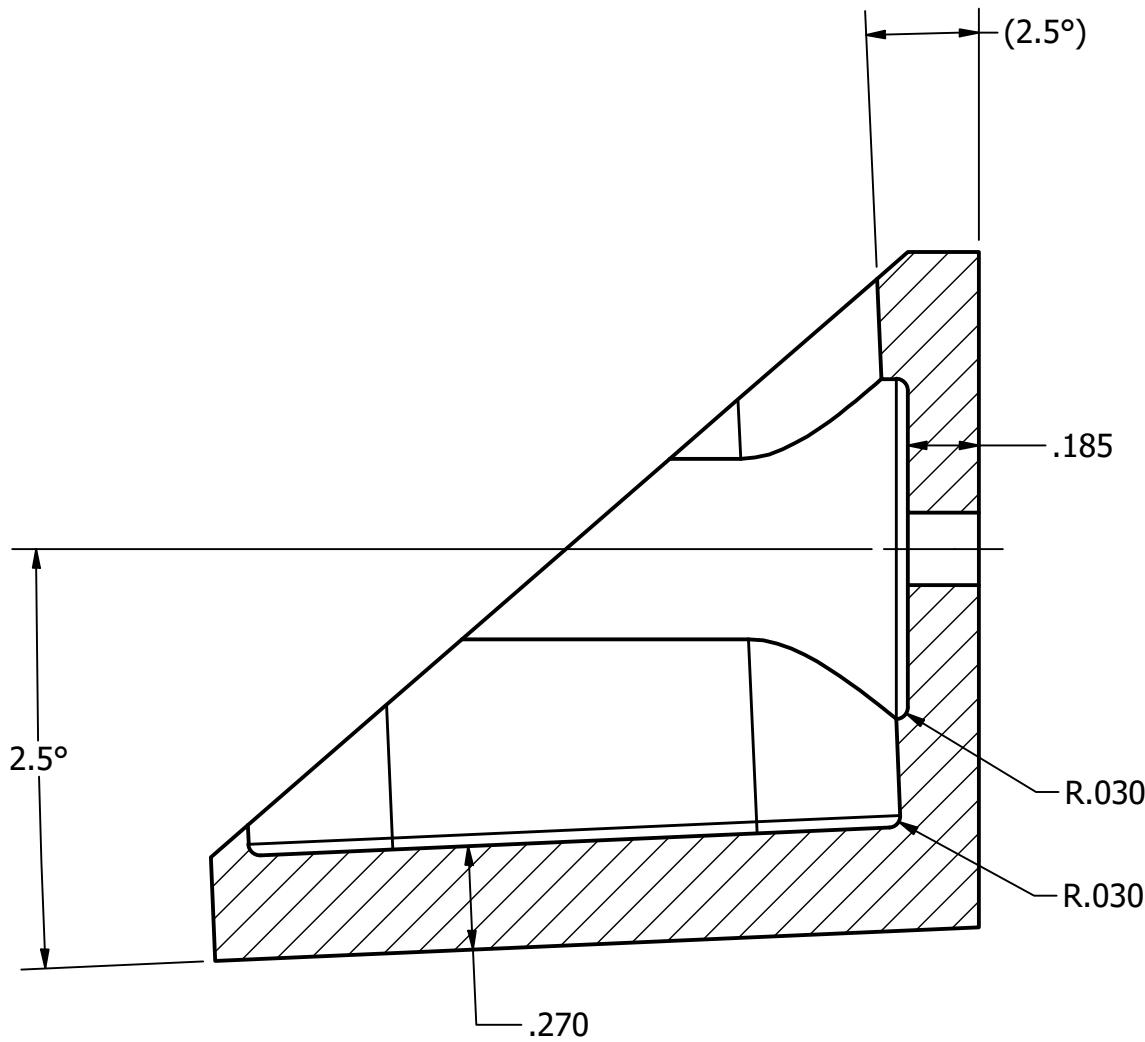
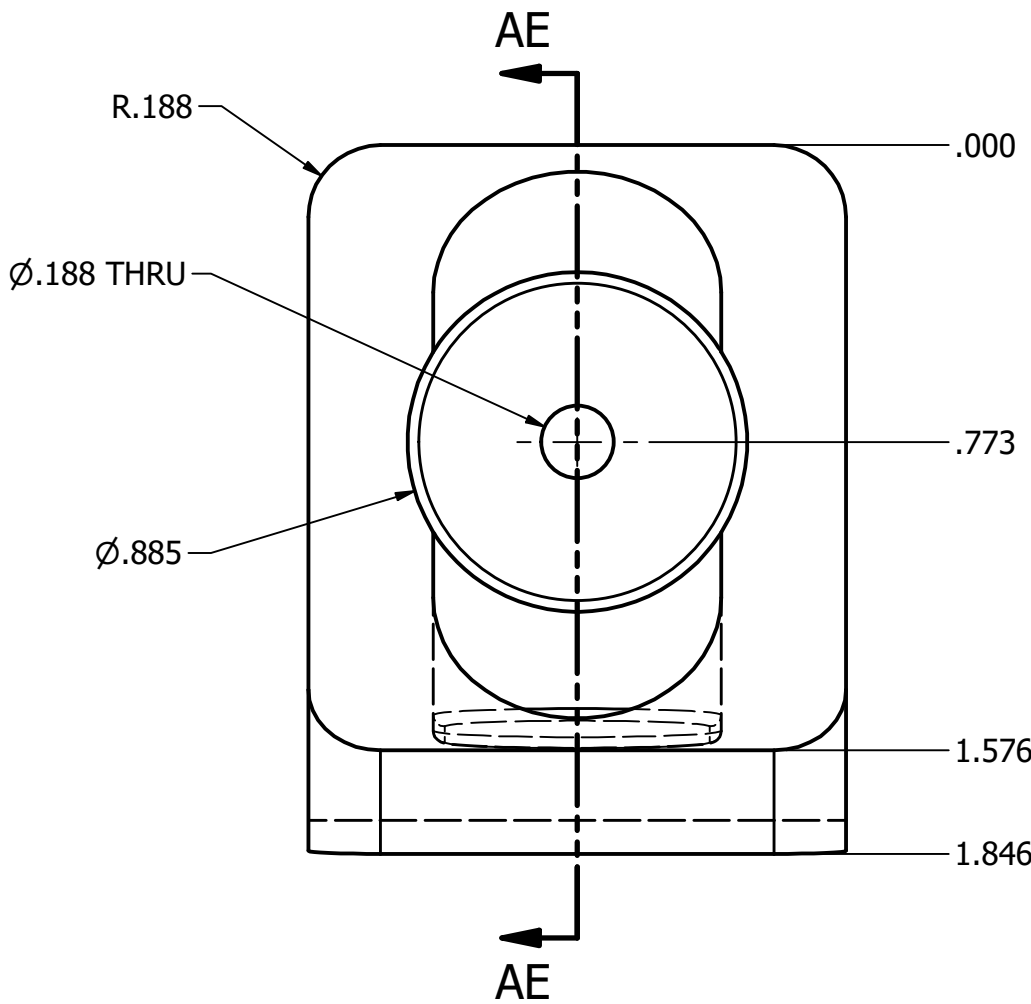
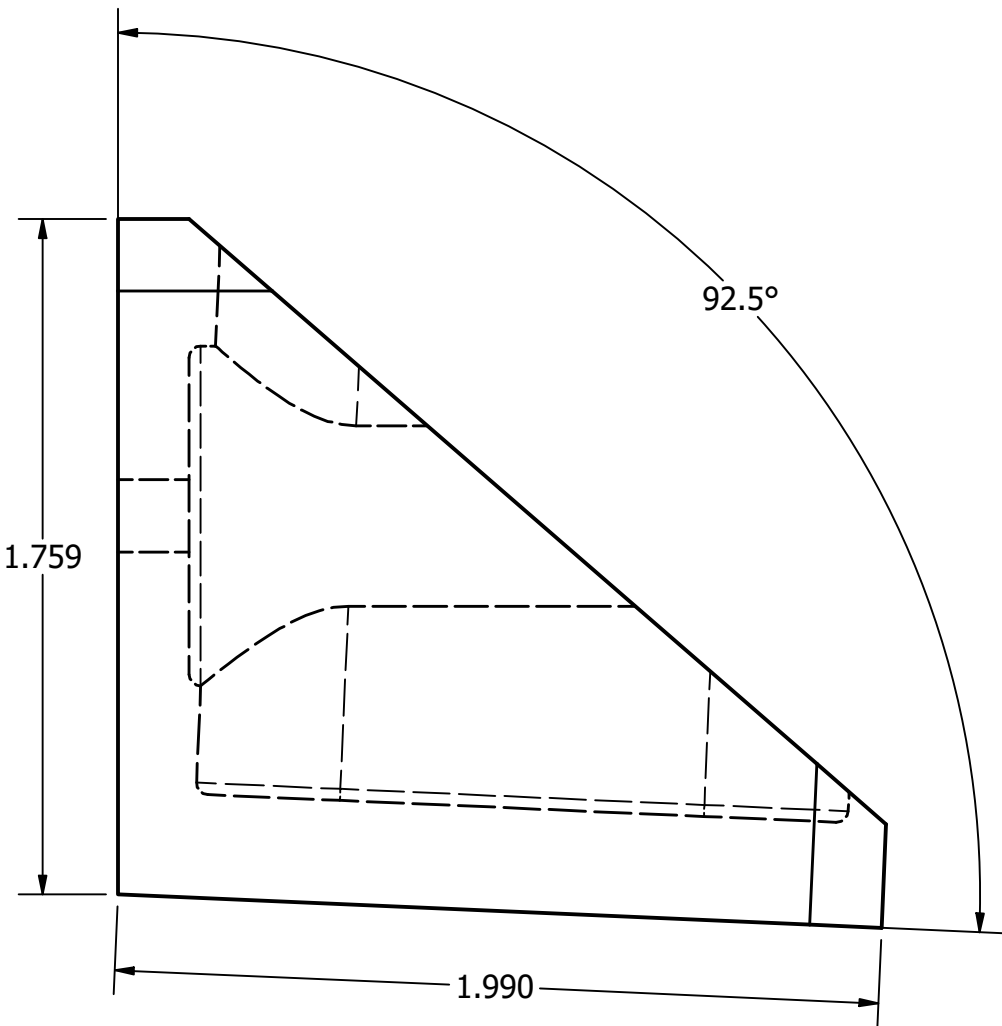
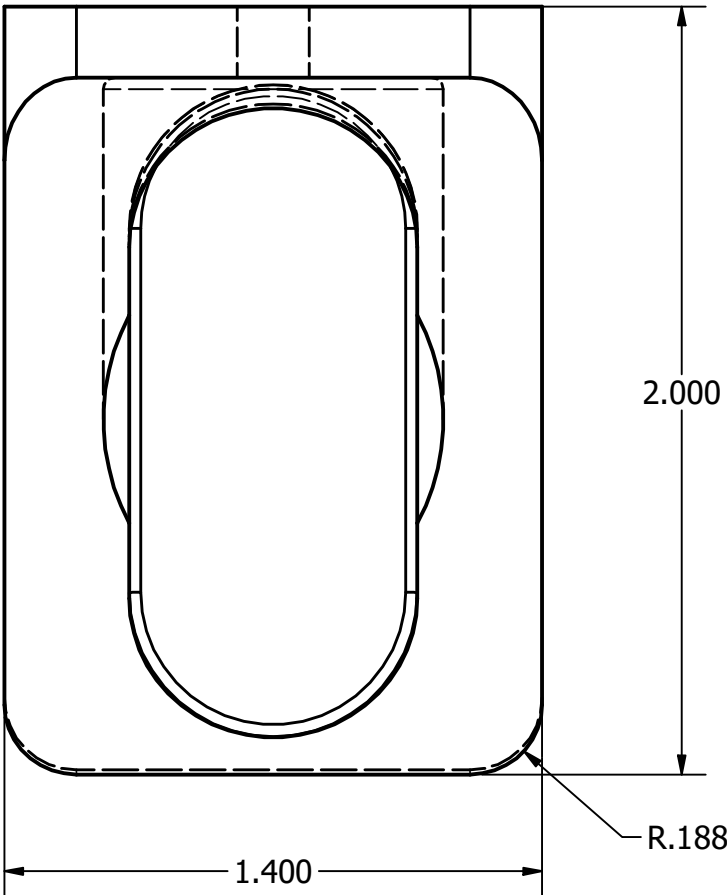
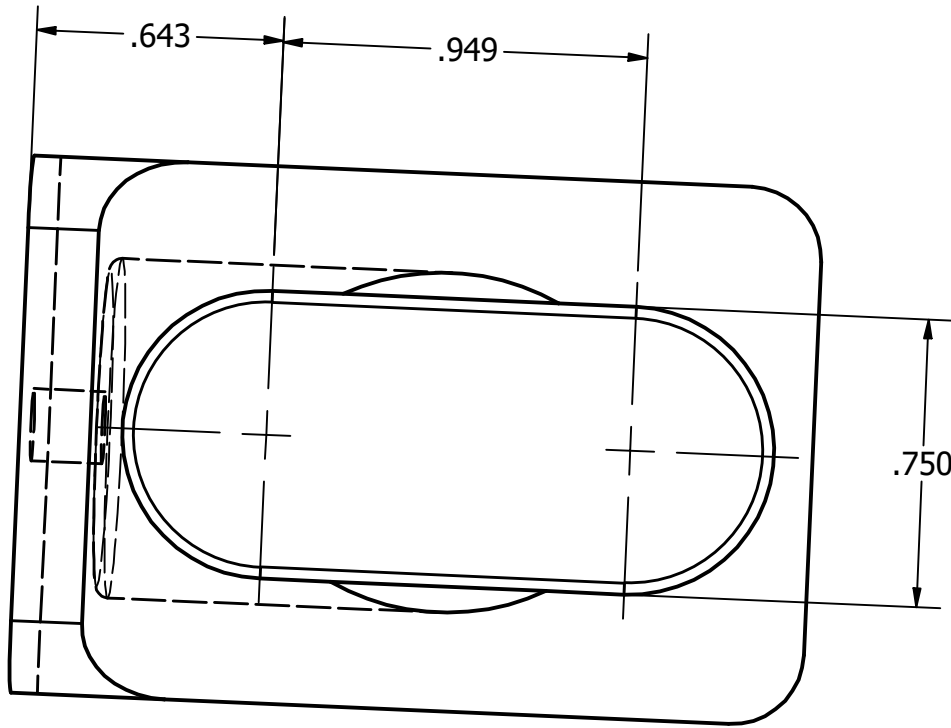
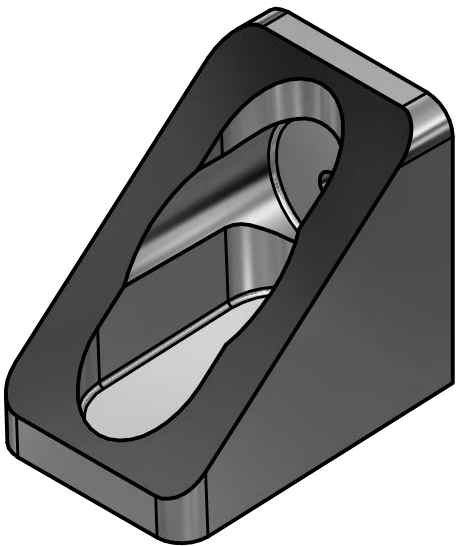
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-24 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2



SECTION AE-AE
SCALE 2 : 1

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PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: \sqrt{R}
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015

.X ±.1
.XX ±.01
.XXX ±.005
ANGLES ±1°

THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

APPROVALS
DRAWN BNS
CHECKED LS
APPROVED REB

DATE
9/24/08
9/24/08
9/24/08

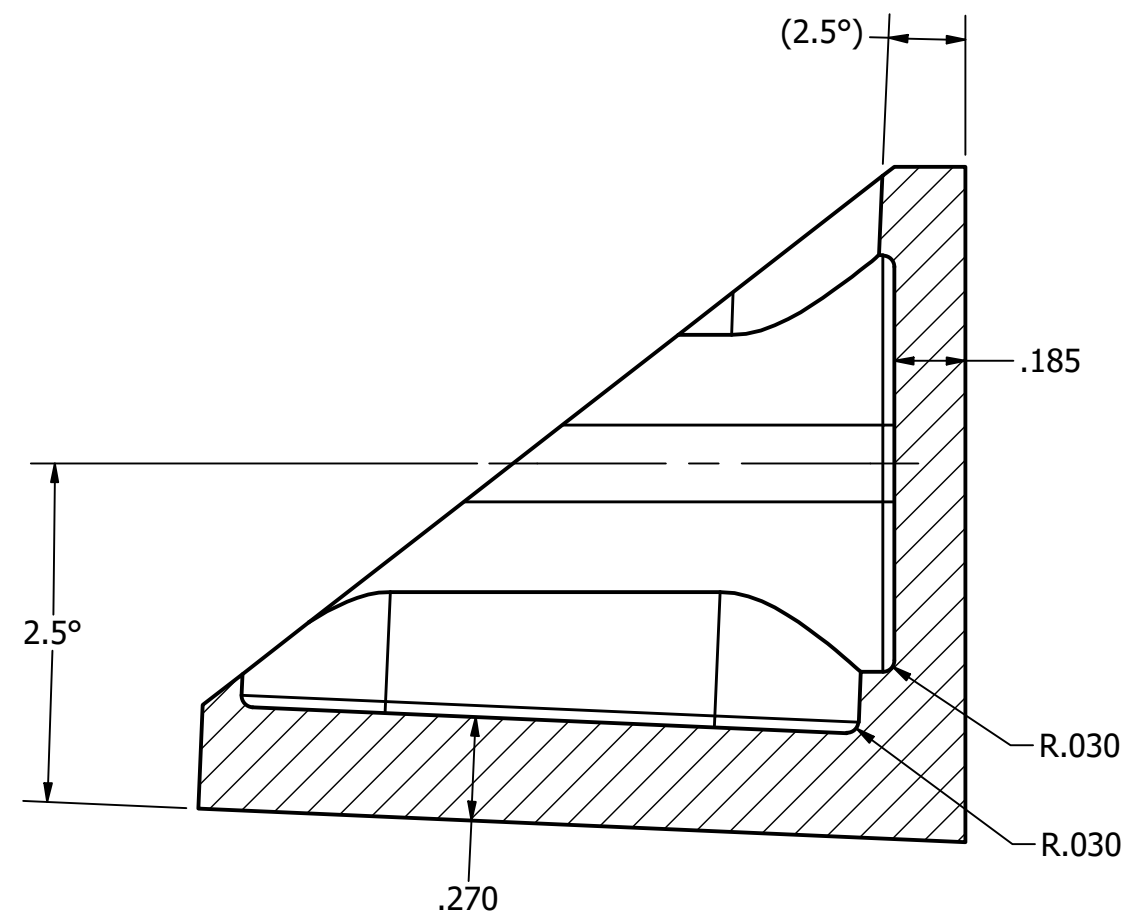
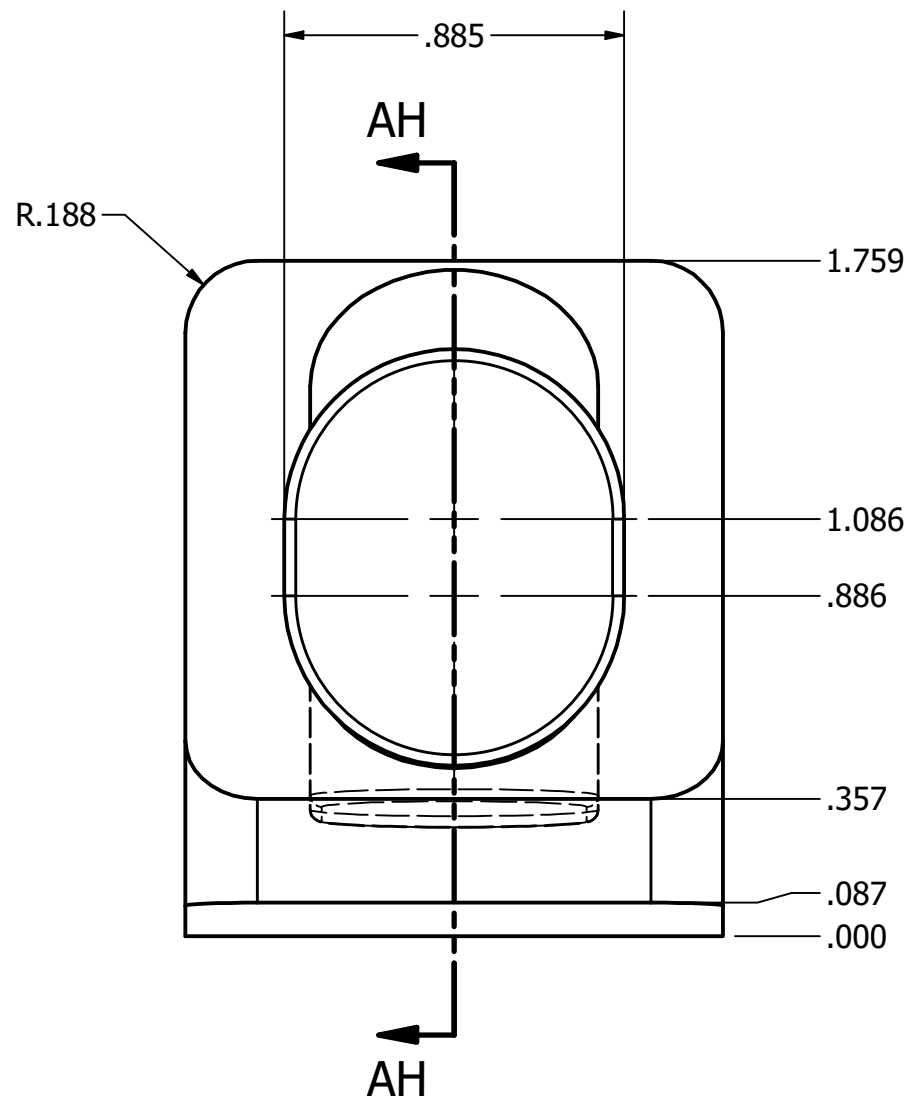
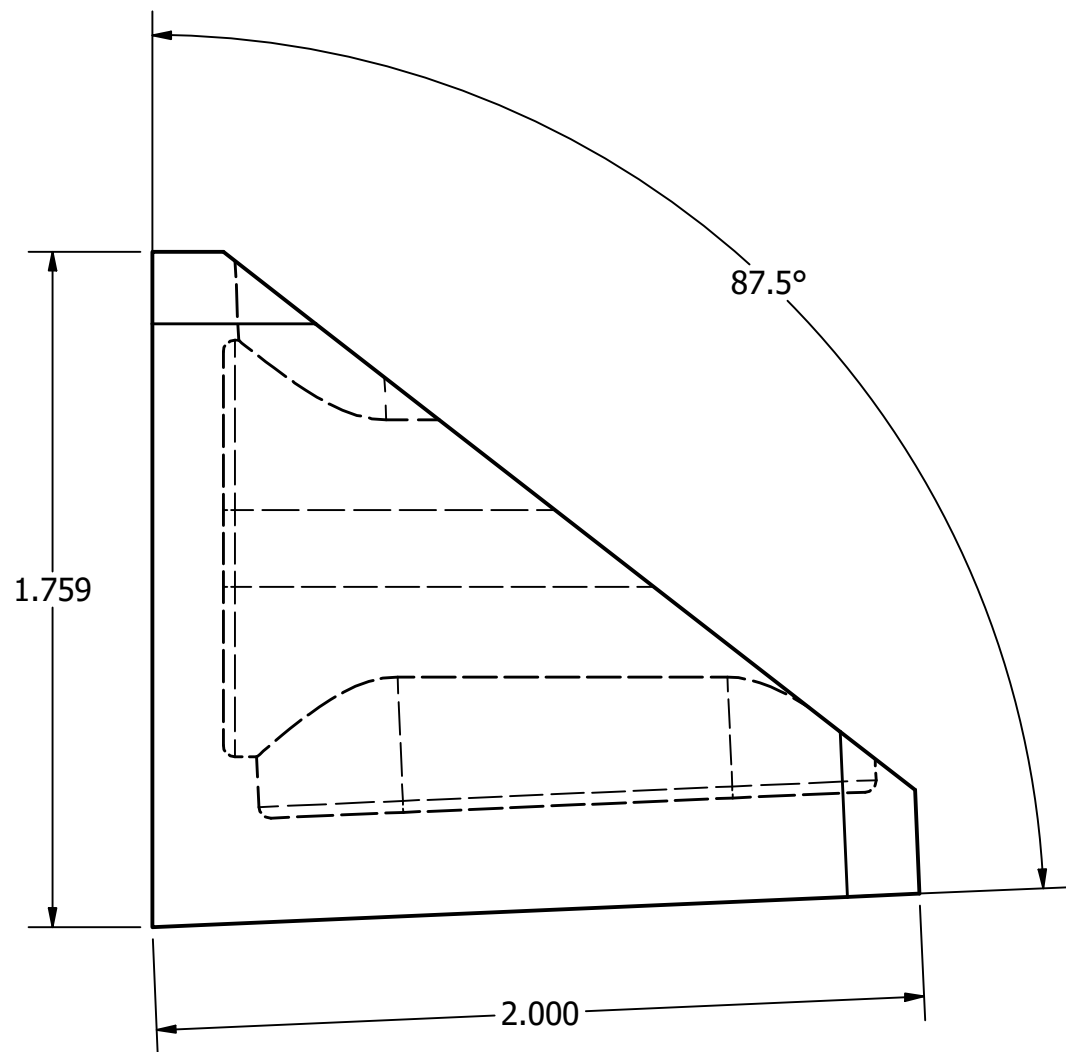
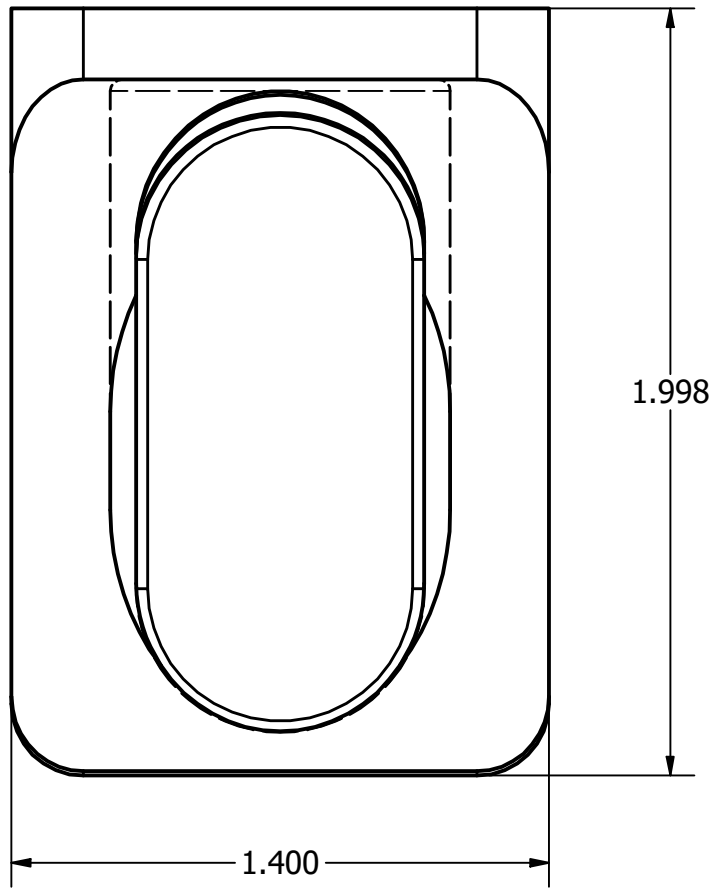
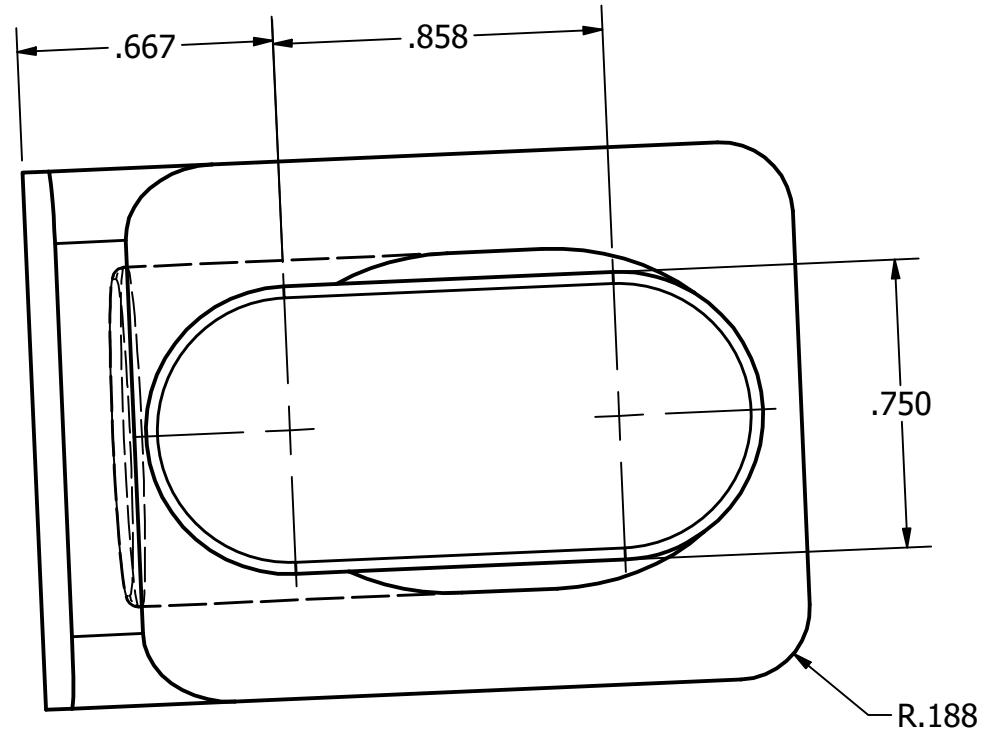
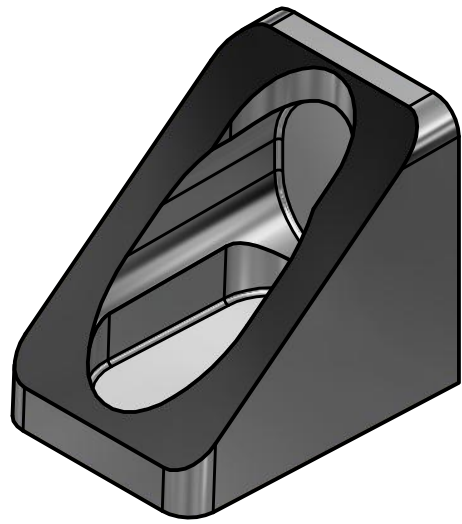
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-25 ANGLE

MATERIAL: 7075-T6 BAR PER AMS-QQ-A-225/9, AMS 4122, AMS 4123, AMS 4186, OR AMS 4187
FINISH: PRIMER PER MIL-PRF-23377J, TYPE 1, CLASS N
ALT FINISH: ANODIZE BLACK PER MIL-A-8625 TYPE II, CLASS 2



SECTION AH-AH
SCALE 2 : 1

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DIMENSIONS INTERPRETED
PER ASME Y14.5-2009
DIMENSIONS IN INCHES
SURFACE ROUGHNESS: \sqrt{R}
REMOVE BURRS & BREAK EDGES
0.005 TO 0.015
.X ±.1
.XX ±.01
.XXX ±.005
ANGLES ±1°

THREADS
INTERNAL: CLASS 2B
EXTERNAL: CLASS 2A

APPROVALS		DATE
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